

Work Order ID 148952

July 12, 2016 9:46:04 AM

148952

Ship July 15.

Page 1

Item ID: D145-762-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube with Standard Wearplates Fits LH or RH
 Start Date: 7/12/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/15/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SA Date: 7/12/16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D145-762-013 CHG005								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.01							
120									
QC	Memo	0.01							
Quality Control									

DAS 21 160712
 DAS 21 9-89
 DAS 21 9-89
 DAS 26 9-89
 DAS 26 9-89
 DAS 26 9-89

JUL 13 2016

JUL 12 2016

JUL 13 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Work Order ID 148952***148952***

Page 2

July 12, 2016 9:46:04 AM

Item ID: D145-762-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Stop ***NS2***Start Date: 7/12/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130						DAS			
Packaging	Memo	0.00				27			
Packaging	Identify and pack for shipping as per PPP D145-762-013					9-89			
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.02							
140									
QC	Memo	0.02							
Quality Control									

JUL 13 2016

DAS
21
9-89
JUL 13 2016
DAS
21
9-89
JUL 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

July 12, 2016 9:46:08 AM

148952

D145-762-013

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VRF:JLM IPP REV:B
13.11.14 AS PER IIN REV.C DD VRF:JLM IPP REV:C 14.11.24 as
per ecn14-654/chg003 DD VRF:JLM IPP REV:D 15.06.11 IIN REV.D
DD VRF:JLM IPP REV:E 16.02.05 IIN REV.E (ecn16-514)
DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D145-762-043		Manufactured	No			110	Each	0.0000	1	1		9-89	DAS 26 9-89
D145-762-043									**	148954			
Replacement Std Skidtubes													
D145-762-053		Manufactured	No			110	Each	0.0000	1	1		9-89	DAS 26 9-89
D145-762-053									**	148956			
Replacement Wearplates for Standard Skidtubes Fit LH or RH													
AN6C52A		Purchased	No			110	Each	31.0000	2	2		9-89	DAS 26 9-89
AN6C52A									**				
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		31							
				m134535		31							
D5300-1		Manufactured	No			110	Each	14.0000	2	2		9-89	DAS 26 9-89
D5300-1									**				
GHL Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST163		14							
				141838		14							
D5301-1		Manufactured	No			110	Each	14.0000	1	1		9-89	DAS 26 9-89
D5301-1									**				
GHL Plug													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST162		14							
				141839		14							

Picklist Print

July 12, 2016 9:46:09 AM

Page 2

Work Order ID: 148952

148952

Parent Item: D145-762-013

D145-762-013

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

110

Each

103.0000

2

2

MS21043-6

NUT

DAS

6

9-89

DAS

26

9-89

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

5

m134365

5

OVER007

30

m135135

30

ST302

48

m134817

48

DAS
27
9-89

JUL 12 2016

July 12, 2016 9:46:04 AM

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Item ID: D145-762-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Stop *NS2*

Start Date: 7/12/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/15/2016 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: SA Date: 7/12/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

5.2 D145-762-013/-113 Skidtube Parts List

Item	Qty -013	Qty -043	Qty -053	Qty -113	Qty -153	Part Number	Description
	X					D145-762-013	SKIDTUBE WITH STD WEARPLATES
	1	X		1		D145-762-043	REPLACEMENT STD SKIDTUBE
	1		X			D145-762-053	REPLACEMENT WEARPLATES (STD SKIDTUBES)
				X		D145-762-113	SKIDTUBE WITH TRAINING WEARPLATES
				1	X	D145-762-153	REPLACEMENT TRAINING WEARPLATES (STD SKIDTUBE)
101		1				D4680-041	SKIDTUBE ASSEMBLY
102	2			2		**L321M1024101 OR **B321M1026101	SKID SHOE (REF ONLY)
103	8			8		**BRSP96/25-SK-WS-1 TEILIG OR **BRSP98/25-SK-WS-1 TEILIG OR **01618266098	CLAMP (REF ONLY)
104	8			8		**N/A	OEM BOLT (REF ONLY)
105	8			8		**N/A	OEM LOCKING WASHER (REF ONLY)
106	8			8		**N/A	OEM WASHER (REF ONLY)
110A		1				*D2965	CAP
110B		1				*D2965-3	CAP
111		4				***AELS-1032-225	INSERT
112		2				*AN3C5A	BOLT
113		2				*NAS1149C0332R	WASHER (OR AN960C10L)
114		2				*AN526C1032	SCREW
120A			1			D4682-041	WEARPLATE
120B			1			D4682-043	WEARPLATE
120C			1			D4682-7	WEARPLATE
121A				1		D4769-041	WEARPLATE
121B				1		D4773-041	WEARPLATE
121C				1		D4771-041	WEARPLATE
122			12		12	D4764-1	BUSHING
123			2		2	AN4C42A	BOLT*
124			4		4	AN4C43A	BOLT*
125			6		6	MS21043-4	NUT
130		3				*AELS-1032-130	INSERT
131		3				*AN3C4A	BOLT
132		3				*NAS1149C0332R	WASHER (AN960C10L)
150	2			2		AN6C52A	BOLT
151	2			2		D5300-1	GHL BUSHING
152	2			2		D5301-1	GHL PLUG
153	2			2		MS21043-6	NUT

* PART IS INCLUDED WITH D4680-041 STD SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE